

Date: Friday, 20/06/2008 1:12:26 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FLOOR PROTECTOR AFT LH
Job Number :	39996		
Estimate Number :	11228		
P.O. Number :		Part Number :	D32813
This Issue :	20/06/2008	Drawing Number :	D3281 REV. D
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	///	Drawing Revision :	D
Previous Run :	39161	Material :	
	Type :	Due Date :	05/07/2008
	THERMOFORMING	Qty:	10 Um: Each
Written By :			
Checked & Approved By :	<u>20 08.6.20</u>		
Comment :	Est Rev.A 04.07.01 New issue KJ/JLM Est Rev B 07.08.07 Thermoform in house DL Est Rev. C 08.02.06 To reflect updated Dwg. DL Est Rev. D 08.04.15 Material Change DL		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MLEXS093F600602	GE PLASTICS LEXAN SHEET
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Comment: Qty.: 4.3330 sf(s)/Unit Total : 43.3300 sf(s)
 GE PLASTICS LEXAN SHEET

Material Batch Number M106751 M106751

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

3.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 009

Dwg. Rev. D
 Folio Rev. B

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BB 08/06/26 X10

BB 08/06/26 X10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 20/06/2008 1:12:26 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR AFT LH

Job Number: 39996

Part Number: D32813

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 08/07/02 X9

BB 08/06/26 X1

10

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

BB 08/07/02 X9

BB 08/06/26 X1

10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

8/7/4

50

10X

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/08

Job Completion



U 08-07-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 39990
Description: Floor Protector, Aft LH		Part Number: D3281-3
Inspection Dwg: D3281	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DB Date: 08/06/26

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	+/-0.100	17.25	✓		Tape	
17.1	+/-0.100	17.1	✓		Tape	
14.3	+/-0.100	14.3	✓		Tape	
0.95	+/-0.030	0.95	✓			
0.25	+/-0.030	0.25	✓			
3.1	+/-0.100	3.1	✓			
0.050	Min	0.056	✓			
0.070	+/-0.010	0.075	✓			

Measured by: DL Date: 08/06/26
 Audited by: DB Date: 08/06/26
 Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	

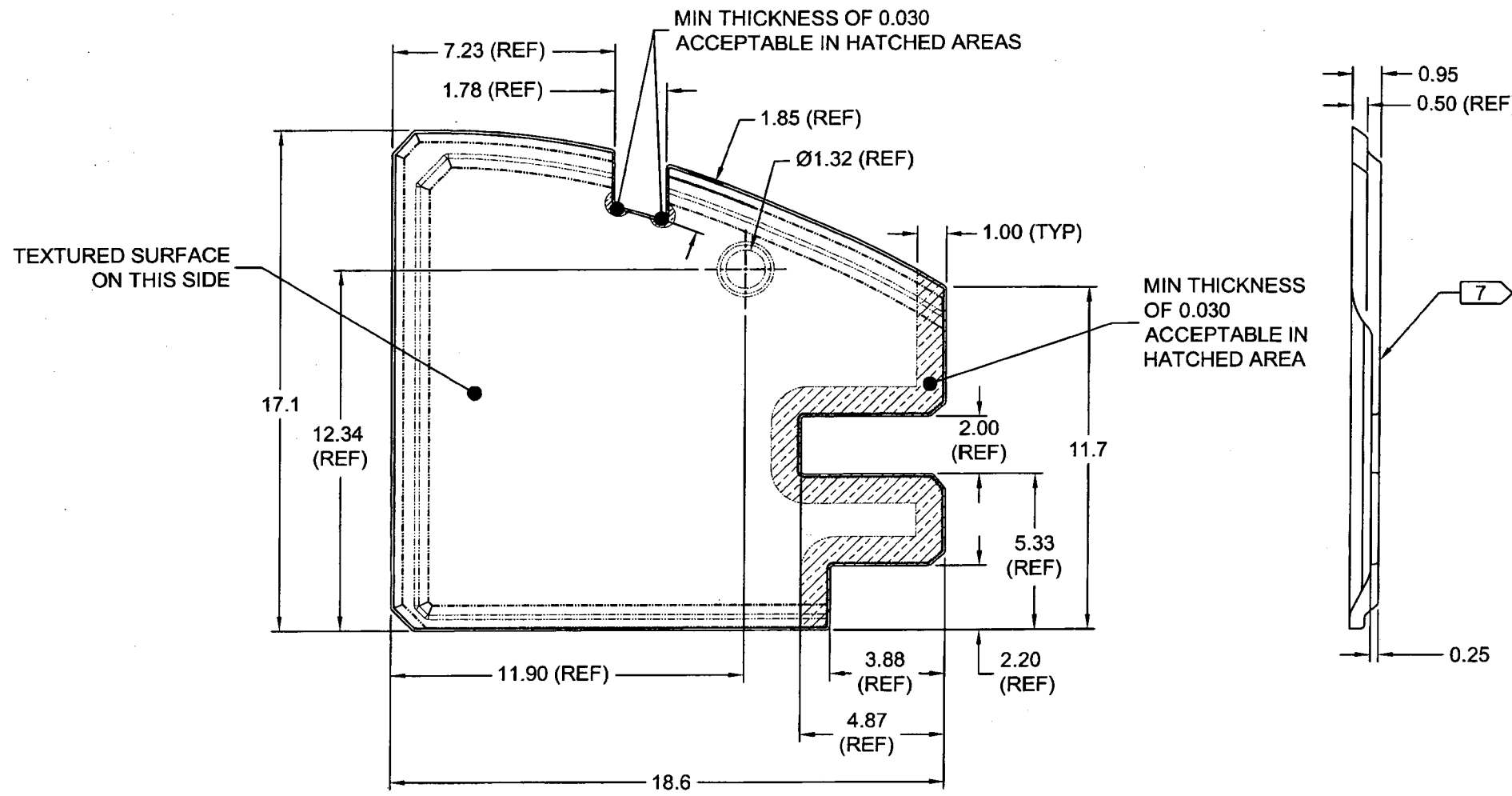
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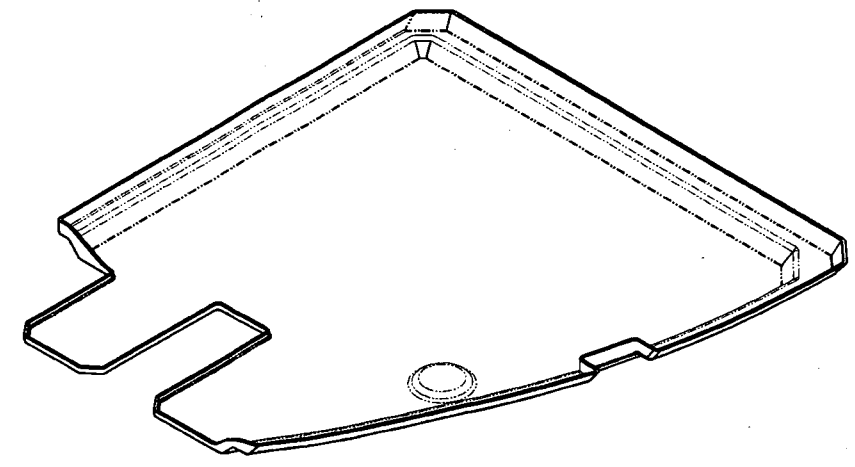
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D3281-1 FLOOR PROTECTOR



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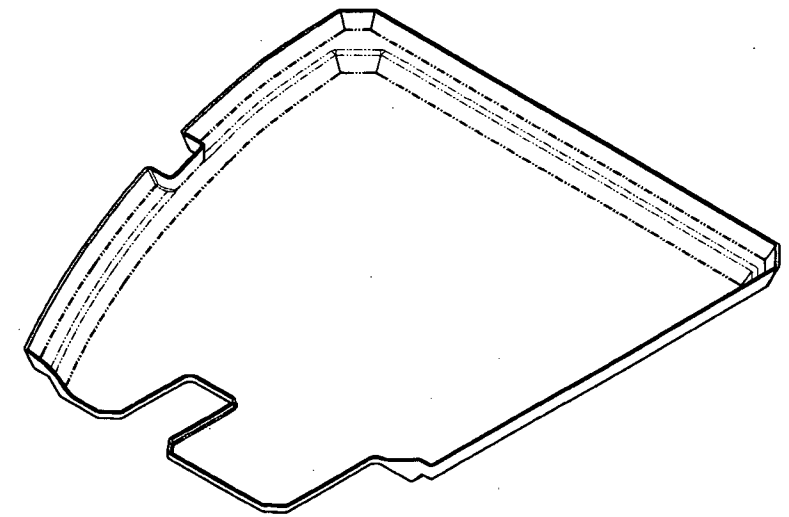
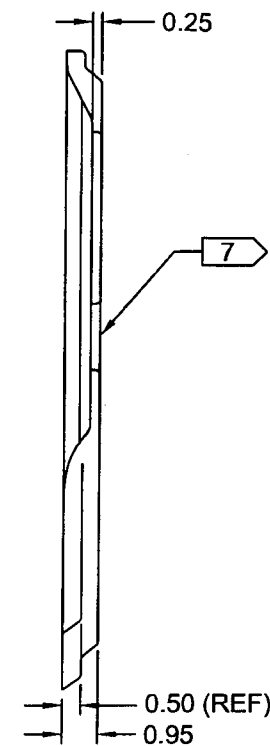
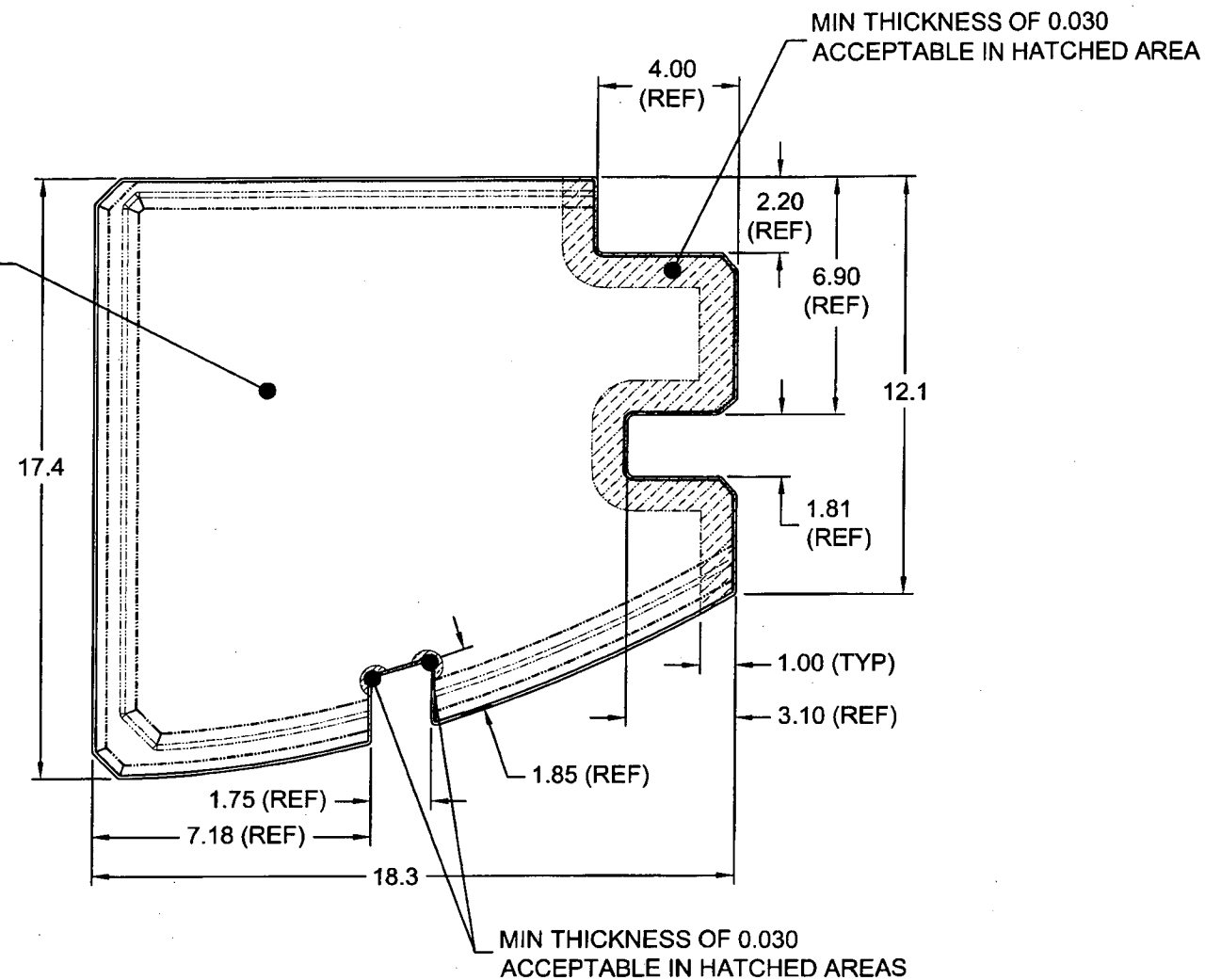
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05.04.11 WPD

D3281-1 NOTES:

- 1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.95 lb

D	THICKNESS 0.093 WAS 0.125, MIN THICKNESS 0.070 WAS 0.080, P/N AND B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2, A7-3, A7-4); D3281-4 NOW ON PAGE 4; CORRECT WEIGHTS (ZN A8-1, A8-2, A8-3, A8-4)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS: COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	Pat		
CHECKED	3	DRAWING NO.	REV. D
MFG. APPR.	Pat	D3281	SHEET 1 OF 4
APPROVED	WPD	TITLE	SCALE
DE APPR.	Pat	FLOOR PROTECTOR	NTS
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D3281-2 FLOOR PROTECTOR

D3281-2 NOTES:

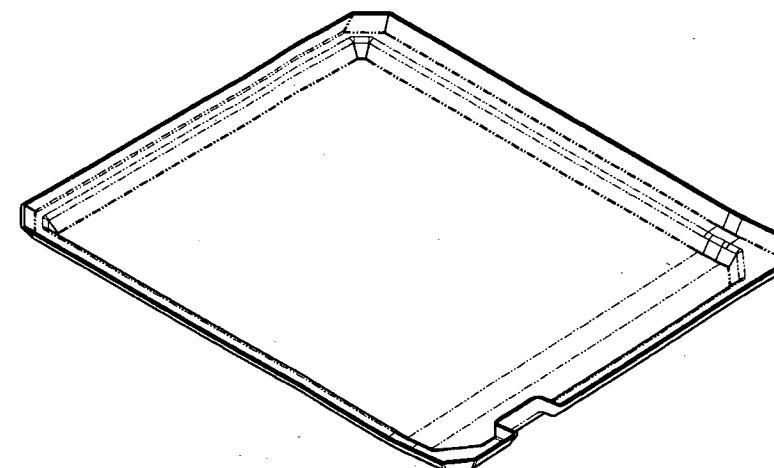
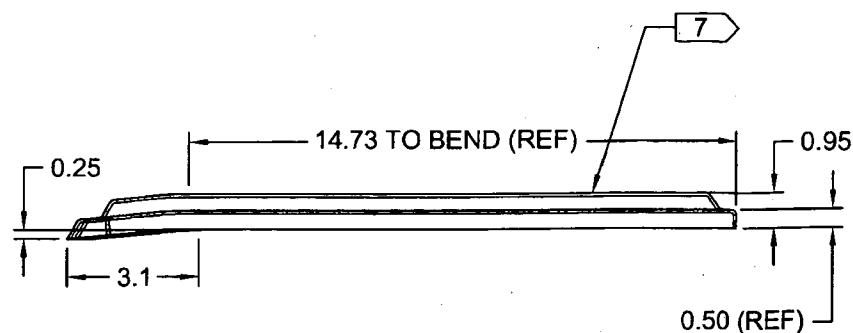
- 1) THERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.97 lb

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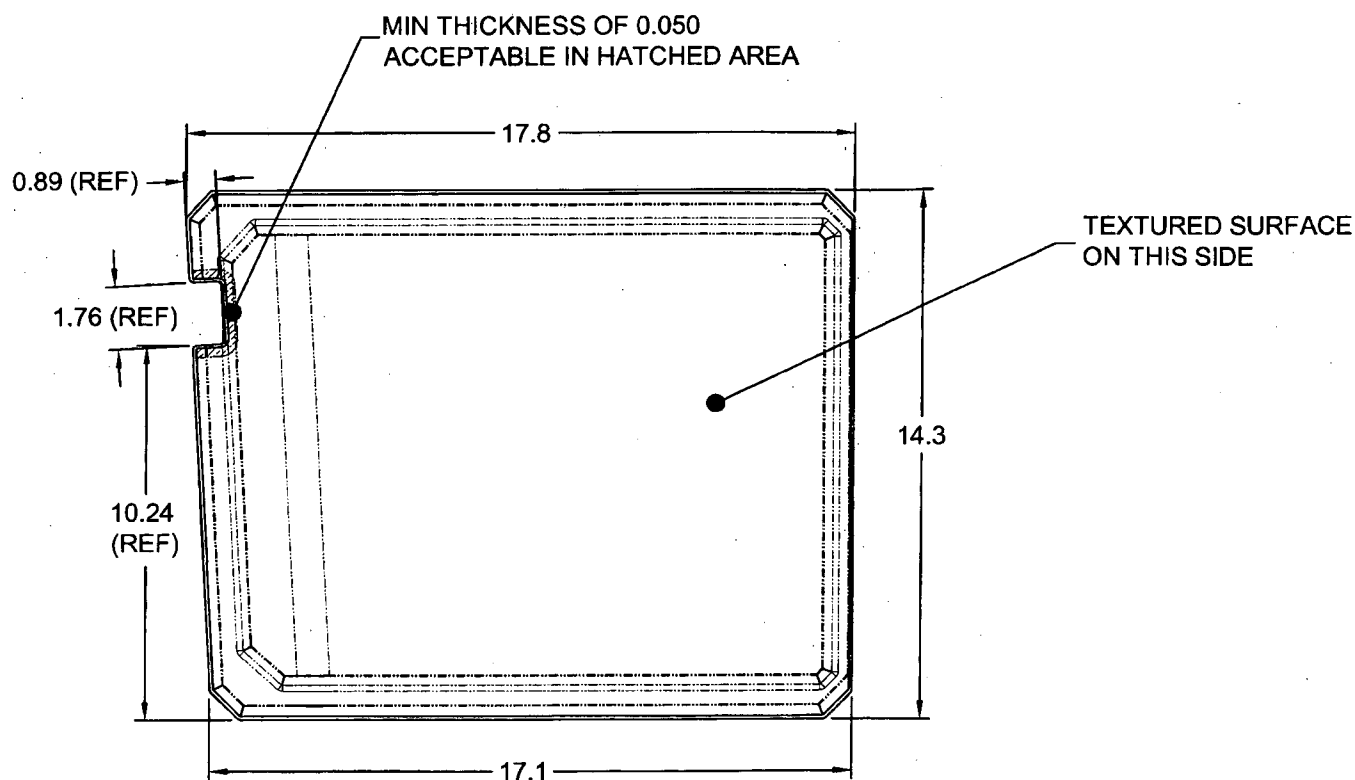
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D3281-3 FLOOR PROTECTOR

D3281-3 NOTES:

- 1) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb



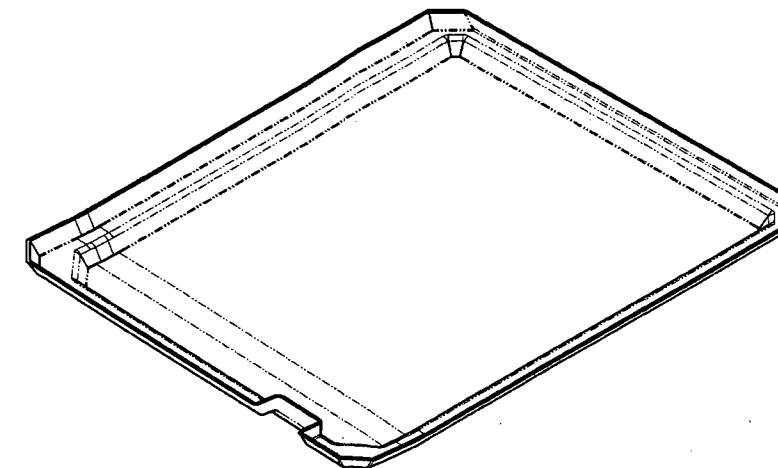
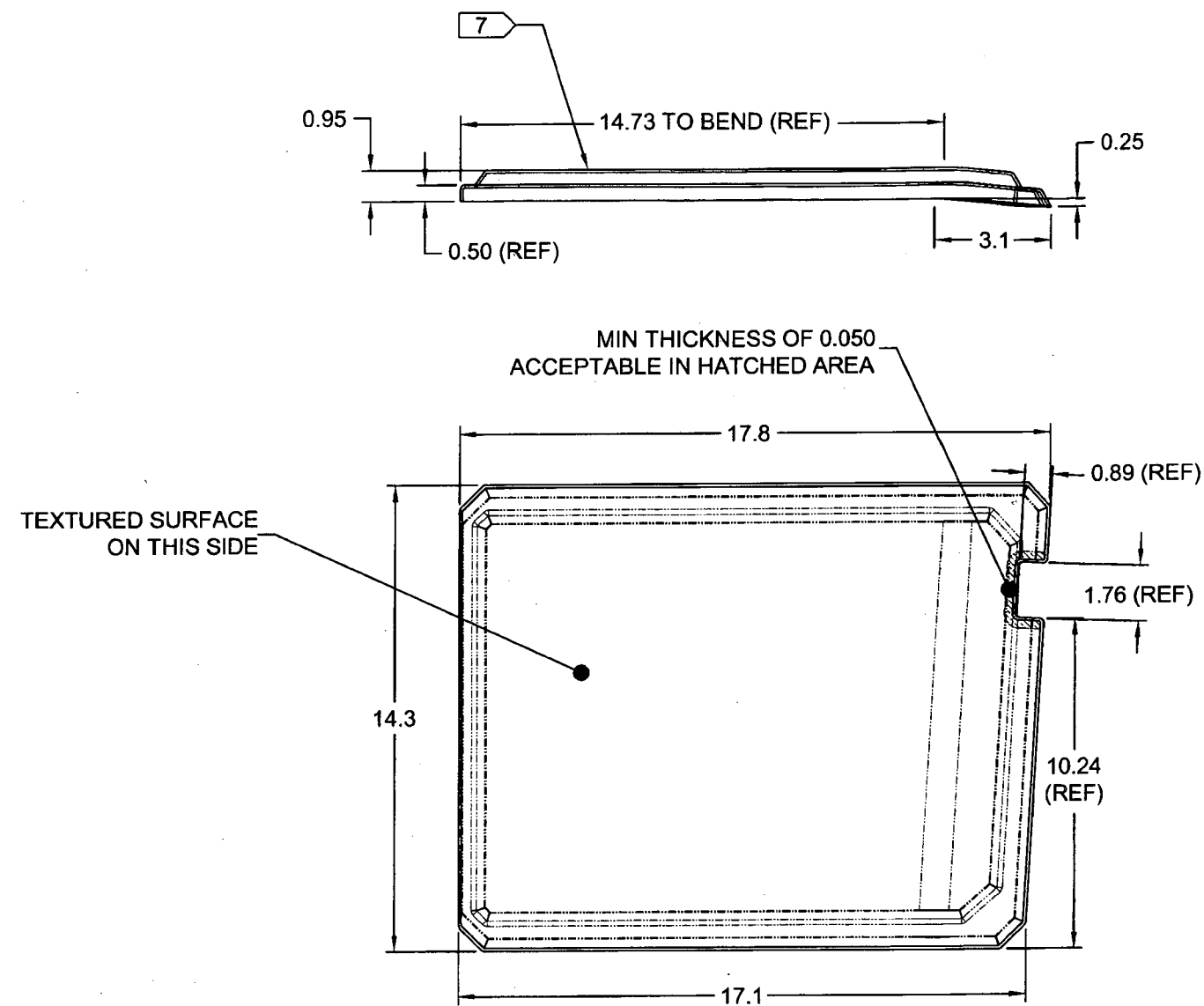
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D3281-4 FLOOR PROTECTOR

D3281-4 NOTES:

- 1) THERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-4" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb

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